

Work Order ID 76131

76131

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Monday, November 07, 2011 11:10:37 AM

Item ID: D2648-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearpad

Start Date: 11/7/2011 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 11/16/2011 Req'd Qty: 16.00 ***16*** Customer:

Reference:

Approvals: Process Plan: *[Signature]* Date: 11-11-07 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2648	Rev D								

100 0.00

100

Waterjet

FLOW CNC Waterjet

1010 . 063

FLOW WATER JET

Memo

1-Cut as per Dwg D2648

*****CUT WITH FILE D2648-1*****

Dwg Rev: *P*

Prog Rev: *D*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

110

QC

Quality Control

Memo

0.00

112-2-21

112-2-21

(Signature)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>1</u>	<u>12</u>	<u>02</u>	<u>22</u> (20)
130 *130* Small Fab Small Fab	Small Fab Memo Deburr if necessary	0.00 0.00							
140 *140* Brake NC Brake NC	NC BRAKE Memo 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3	0.00 0.00							

N/A

So 12/02/22

(20)

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Large Fab	Weld per dwg A/R Hardcoat steel Batch <i>M117964</i> Large Fab	0.00				<i>(20)</i>			<i>12-02-23 JBL</i>
	Memo	0.00							
	1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary								
160 *160* QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00				<i>20x</i>	<i>Ø</i>		<i>12-02-24</i>
170 *170* QC	QC5- Inspect part completeness to step on W/O	0.00				<i>n</i>	<i>12</i>	<i>02</i>	<i>24</i>
Quality Control	Memo	0.00							<i>(23)</i>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 QC: _____ Date: _____ SPC (Y/N): _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
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180

Powdercoat

Powder Coating

Memo

START TIME: 10:00

OVEN TEMPERATURE: 320 OF

FINISH TIME: 10:30

190	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

190

QC

Quality Control

Memo

200	Identify as per dwg & Stock Location: 231A	0.00							
-----	--	------	--	--	--	--	--	--	--

200

Packaging

Packaging

Memo

20x M-12/22/27

20x d del 12/27/27
 (counted) a mca 20x

12/27/27 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 11/16/2011 Req'd Qty: 16.00 ***16*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

12/2/27
MF
12-02-27

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Page 1

Monday, November 07, 2011 11:10:42 AM

Work Order ID: 76131

76131

Parent Item: D2648-3

D2648-3

Parent Item Name: Wearpad

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP: E02.09.18Re-format; Incorporated D2648-1KJ/RF
IPP Rev:F Now on Waterjet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M1010S16GA

Purchased

No

100

sf

88.7000

0.075

1.263158

1.5

M1010S16GA

1812-2-21

1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT019

88.7

116791

27.4

117500

29.3

118965

32

117500

20

W/O:		WORK ORDER CHANGES					
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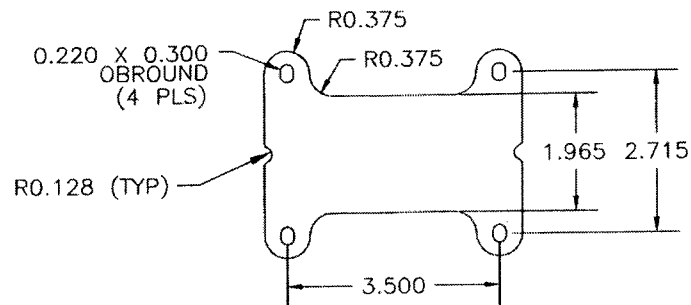
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

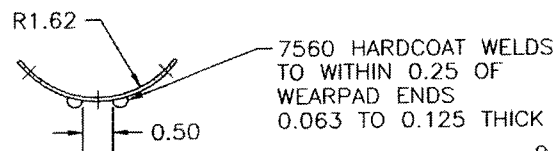
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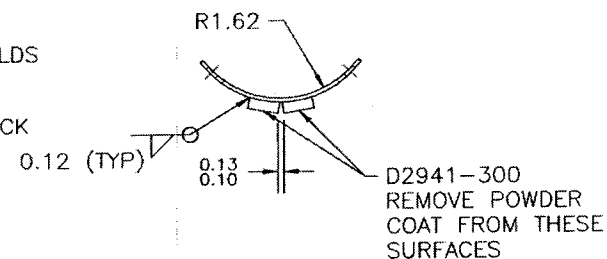
D2648-1 FLAT PATTERN



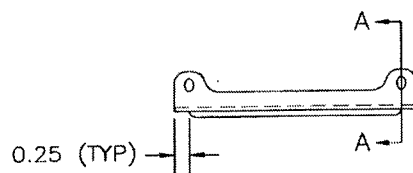
SECTION A-A



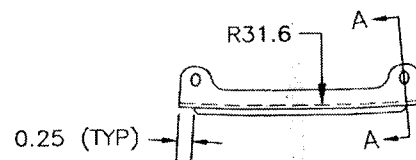
SECTION B-B



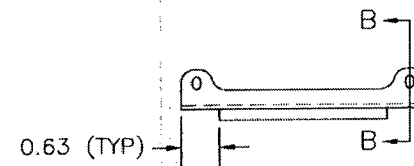
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK) NO. 76131
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

0111-07

RELEASED
12.20 05



D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BOLLENG, WA
CHECKED	APPROVED	DRAWING NO. D2648
DATE	TITLE	WEARPAD
99.11.17		SCALE 1:2

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